

Work Order ID 72368



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Monday, July 25, 2011 9:10:40 AM

Item ID:	D350-591-215	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Heli-Access-Step, Short LH					
Start Date:	7/25/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	8/2/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	7-27-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3168	Rev A								
DSI 9472	A								

100
 DOCUMENT CONTROL
 DC
 Document Control

Memo
 Photocopy bluefile and type labels as per PPP D350-591-215 CHG003

0.00

0.00

8/6/14

for BG 11-9-14 (2)

110
 Large Fab
 Large Fab

Memo
 1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168
 2-Drill extrusion as per Dwg D3168 using Jig DT8680 for rivets. (Use only 1st 6holes)
 3-Deburr

0.00

0.00

11.08.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>Sulo 8/22</i>		<i>(42)</i>			
130 Large Fab Large Fab	Large Fab Memo 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8780, weld Fwd End Plate as per QSI 004 & Dwg D3168 A/R Aluminum Rod <i>M114703</i> 3-Grind End Plate flush <i>M117824</i>	0.00 0.00				<i>2</i>	<i>0</i>		
				<i>11.08.22</i>					
				<i>11.08.22</i>		<i>2</i>	<i>0</i>		
140 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<i>2</i>	<i>0</i>	<i>8/24/08/22</i>	

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Revision ID:

Item Name: Heli-Access-Step, Short LH

Stop



Start Date: 7/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

8 u108/30



QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QS1005 4.1

0.00

11.09.03



HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

50 1169/07



QC

Memo

0.00

Quality Control

24

x2

2

W/O:		WORK ORDER CHANGES					
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Start Date: 7/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
	Large Fab					2	0		
Large Fab	Memo	0.00							
Large Fab	Rivet Leg Assembly as per Dwg D3168								
200		0.00							
	Large Fab					2	0		
Large Fab	Memo	0.00							
Large Fab	1-Bevel Aft end for welding								
	2-Inspect for foreign object as per QSI 024								
	3-Weld Aft End Plate as per QSI 004 & Dwg D3168								
	A/R Aluminum Rod <u>M114514</u>								
	4-Grind End Plate flush								
210		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									

11.09.07

11.09.07

11.09.12

5/11/13

x2 0

12
27

Pro →

W/O: 72368		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/09/13	210	change step to QC 10	[Signature]	11.09.16	N/A	[Signature]	S 11/09/13

Part No: D350-591-215 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 8/2/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M183B</i> Memo	0.00 0.00				<i>2</i>		<i>BR 11-9-B</i>	
260  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>26H</i>	<i>0</i>	<i>M 11/09/13</i>	
270  Packaging Packaging	Pick Kit Memo	0.00 0.00				<i>SP</i>		<i>11-09-14</i>	

W/O:		WORK ORDER CHANGES					
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Required Date:	8/2/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
290	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-215								
	Location:								
	PPP Rev:								
300	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

72
24

11/9/14 sl (20)

11/9/16 JF

MF 11-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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The following information is provided for the purpose of providing a general overview of the information contained in the report. It is not intended to provide a detailed description of the information contained in the report. The information is provided for the purpose of providing a general overview of the information contained in the report. It is not intended to provide a detailed description of the information contained in the report.

**Required Date: 8/2/2011**

Required Qty: 2.00

Comments: IPP Rev: A 02.10.17 New issue KJ/RF
IPP Rev:B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C  Step Extrusion		Manufactured	No			110	Each	117.7000	0.5	1		11.08.17.	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				HALL				108					
				64409				6					
				<u>68293</u>				102		(X1)			
				WA				9.7					
				46910				2					
				66970				7.7					
D3067-1  End Plate		Manufactured	No			130	Each	105.0000	1	2		11.09.07	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				84					
				67582				2					
				<u>70700</u>				82		2			
				WA016				21					
				68214				21					
D3169-1  Support		Manufactured	No			130	Each	11.0000	1	2		11.09.07	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA016				11					
				<u>26685</u>				11		2			

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 72368

Parent Item: D350-591-215

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 2.00

Required Qty: 2.00

D3077-1

Manufactured No

180

Each

24.0000

2

4



Step Leg



11.09.07

Location

Loc Qty

Loc Code

WA013

24

35817

24

180

Each

27.0000

2

4

D3170-1

Manufactured No



Spacer



11.09.07

Location

Loc Qty

Loc Code

Mezz

323578

27

35824

27

180

Each

1,888.000

12

24

MS20600-AD4W4

Purchased

No



Rivets



11.09.07

Location

Loc Qty

Loc Code

ST321

1883

116188

59

117364

1000

117601

200

117885

224

118267

400

WA018

5

116712

5

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 72368

Parent Item: D350-591-215

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 2.00

Required Qty: 2.00

D3067-1

Manufactured No

200

Each

105.0000

1

2



End Plate



11-09-07

Location

Loc Qty

Loc Code

WA

84

67582

2

70700

82

WA016

21

68214

21

2

AN3-35A

Purchased

No

270

Each

93.0000

2

4



Bolt



SP 11-09-14

Location

Loc Qty

Loc Code

ST353

93

117619

3

117794

50

118112

40

4x

AN4-11A

Purchased

No

270

Each

194.0000

6

12



Bolt



SP 11-09-14

Location

Loc Qty

Loc Code

ST356

100

117872

100

ST357

94

110382

1

115316

93

12x

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Work Order ID: 72368

Parent Item: D350-591-215

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 2.00

Required Qty: 2.00

AN4-13A Purchased

No

270

Each

1,212.000

4 8



Bolt



SP 11-09-14

Location

Loc Qty

Loc Code

ST357

1212

117962

18

118078

594

118350

300

118351

300

AN4-16A Purchased

No

270

Each

122.0000

4 8



Bolt



SP 11-09-14

Location

Loc Qty

Loc Code

ST358

122

117514

22

117872

100

AN960JD10 NAS1149D0363J Purchased

No

270

Each

0.0000

4 8



Washer

m 118077

8x



SP 11-09-14

AN960JD416 NAS1149D0463J Purchased

No

270

Each

0.0000

12 24



Washer

m 118384

24x



SP 11-09-14

D2230-1 Manufactured

No

270

Each

251.0000

2 4



Lug



SP 11-09-14

Location

Loc Qty

Loc Code

ST476

251

67826

6

69179

45

69821

100

70974

100

4x

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 72368

Parent Item: D350-591-215

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 2.00

Required Qty: 2.00

D2230-3

Manufactured No

270 Each

194.0000



Lug

2 4
SP 11-09-14

Location

Loc Qty

Loc Code

ST 70
70694 70
ST476 4
53881 4
ST480 120
70973 120

D2732

Manufactured No

270 f

664.8981



Rubber Extrusion

0.5 1
SP 11-09-14

Location

Loc Qty

Loc Code

ST410 664.89811
64283 166.02811
70987 498.87

D2856-400

Manufactured No

270 f

290.3845



Abraison Strip

0.6 1.2
SP 11-09-14

Location

Loc Qty

Loc Code

ST403 73.7149
68076 73.7149
ST409 216.6696
63735 0.6696
71164 216

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Parent Item Name: Heli-Access-Step, Short LH

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

270

Each

1,422.000



Nut

2 4

80 11-09-14

Location

Loc Qty

Loc Code

ST300

1422

117441

662

117601

400

117885

360

4x

MS21042L4

Purchased

No

270

Each

3,565.000



Nut

6 12

80 11-09-14

Location

Loc Qty

Loc Code

ST300

3565

117441

1414

117601

651

117885

1500

12x

W/O:		WORK ORDER CHANGES					
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DESIGN <i>OP</i>	DRAWN BY <i>OP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3168	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, LOW SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *#*

Part No.	Description	QTY -041	QTY -042
D3168-041	Step Assembly, Low Short (LH)	X	
D3168-042	Step Assembly, Low Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3067-1	END PLATE	2	2
D3077-1	STEP LEG	2	2
D3169-1	SUPPORT	1	1
D3170-1	SPACER	2	2
MS20600AD4W4	RIVET	12	12

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3169-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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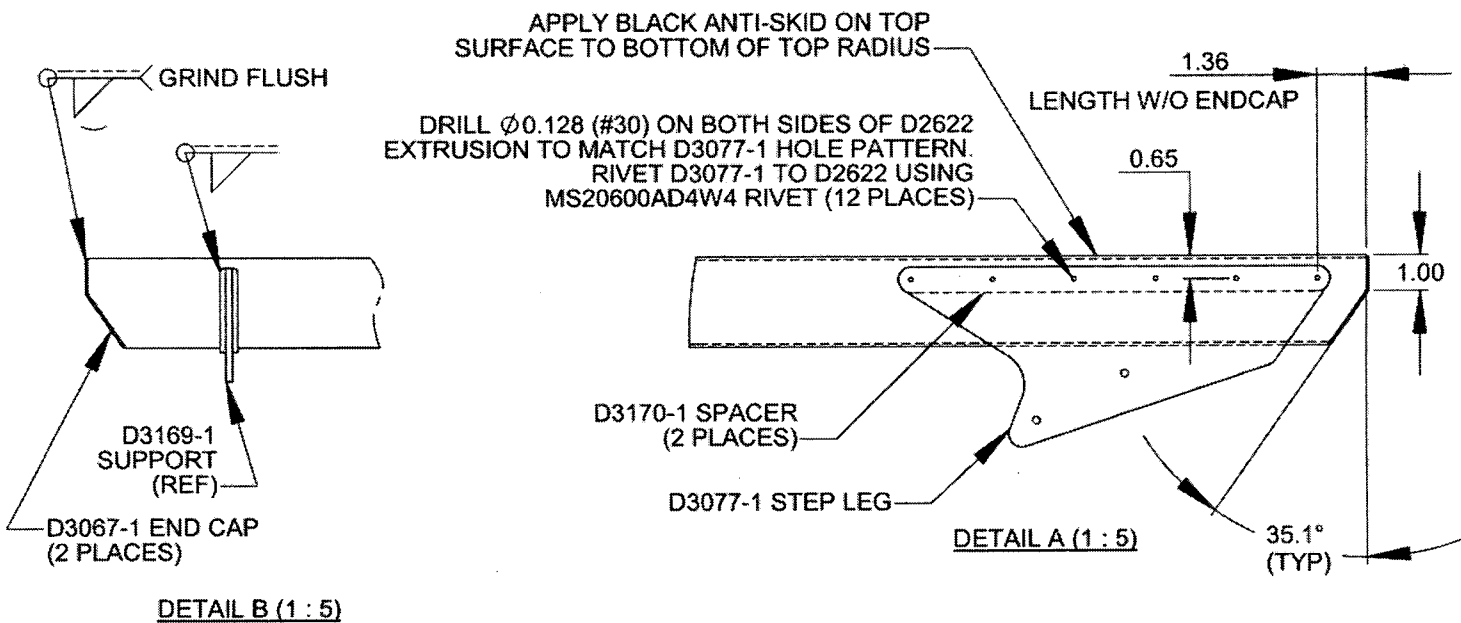
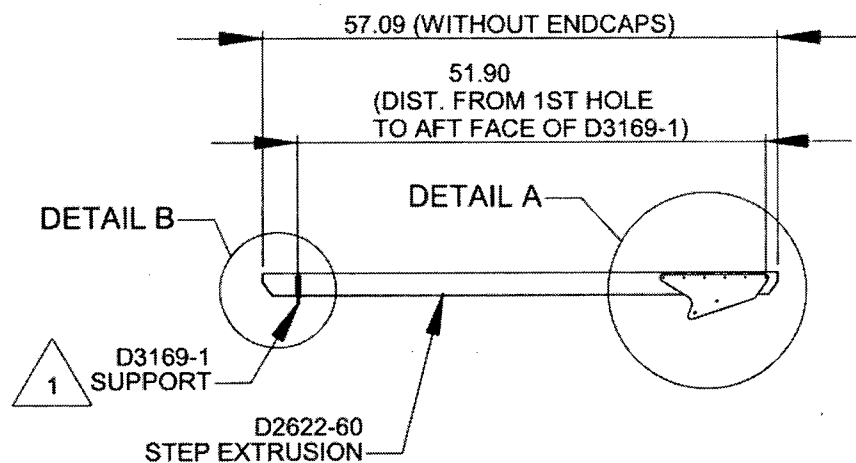
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DART



DESIGN	<i>UP</i>	DRAWN BY	<i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>UP</i>	APPROVED	<i>UP</i>	DRAWING NO. D3168
DATE	02.09.11	TITLE	STEP ASSEMBLY, LOW SHORT	REV. A SHEET 2 OF 2
		SCALE	1:20	

RELEASED
02.09.20



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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT*
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE


For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.






For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	Heli-Access-Step ™, Short Step – High Skid, LH
	X			D350-591-214	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step ™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9472	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT ADDITION	NTS
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